

PLASTIC INJECTION MOLDING WITH MOVEABLE MOLD MEMBERS FORMING SPEAKER GRILL

Abstract

A method and system for producing hollow rib structures for trim components and panels using gas-assisted plastic injection molding. Movable and floating core members are provided in the mold cavity, particularly adjacent structural rib members. After the plastic material is injected into the mold cavity, the plastic is packed in the mold. The moveable core members are then moved creating a void or opening in the mold cavity. Thereafter, gas or another fluid is introduced into the rib members to provide hollow channels in them. The fluent plastic material in the rib member is displaced into the voids forming integral portions of the completed plastic article.